6001 3/4

Work Order ID 109933

109933

December-05-13 2:39:35 PM

Item ID: D3490-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Cross Bolt Spacer

Start Date: 12/05/13 **Start Qty:** 80.00 *80*

Required Date: 12/19/13 **Req'd Qty:** 80.00 *80*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 13-12-05 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3490	Rev A								
100	Hardinge CNC LATHE SMALL	0.00							
100						80	ø		JFC 2013-12-16
Hardinge	**Memo**	0.00	FK 13/12/17						
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA629 & DWG D3490 FOLIO REV: AA DWG REV: A 2-DEBURR AS REQUIRED								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						80			JFC 2013-12-16
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120						80	ø		
QC	**Memo**	0.00	SK 13-12-17						
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 109933

109933

December-05-13 2:39:35 PM

Item ID: D3490-3 **Accept** *N900040100* **Setup Start** *NS1*

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: LG	0.00				80	0		13/12/17
130									
Packaging	**Memo**	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
140	QC21- Final Inspection - Work Order Release	0.00							13/12/18
140									
QC	**Memo**	0.00							
Quality Control									

MF 13-12-18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Folio/Program
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☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
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☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

December-05-13 2:39:38 PM

Work Order ID: 109933 *109933*

Parent Item: D3490-3 *D3490-3*

Parent Item Name: Cross Bolt Spacer

Start Date: 12/05/13 **Required Date:** 12/19/13

Start Qty: 80.00 **Required Qty:** 80.00

Comments: IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	100.7810	0.266	23			
M6061T6R0.750									**				
6061-T6 Round Bar .750"													

Location	Loc Qty	Loc Code
MAT012	100.781	
125552	7.801	
m126852	92.98	

23 JFL 2013-12-16

(MATL NOT PULL OUT)

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
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Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
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Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
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☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD	Work Order:	109933
Description: Crossbolt Spacer	Part Number:	D3490-3
Inspection Dwg: D3490 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.085	+0.030/-0.000	3.0925	✓		Caliper	JFC-01
0.080	+/-0.010	0.077	✓		"	"
Ø0.591	+0.008/-0.001	0.592	✓		"	"
0.050 x 45°	+/-0.010 x 0.5°	0.050	✓		"	"

Measured by:	JFC
Date:	2013-12-16

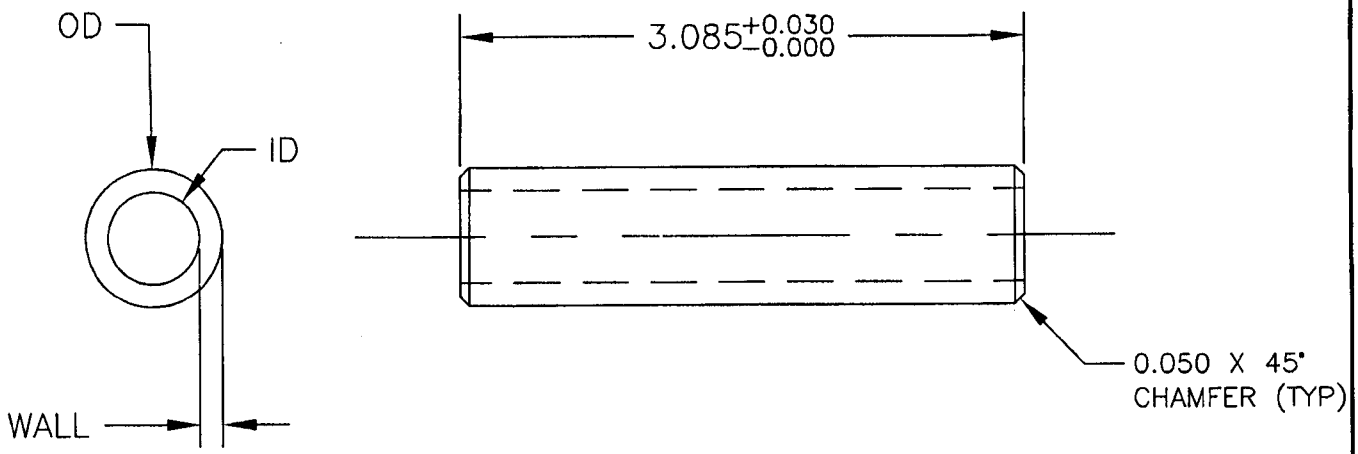
Audited by:	
Date:	13-12-17

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.27	New Issue	KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
PH	PH		
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3490	SHEET 1 OF 1
DATE		TITLE	SCALE
06.01.04		CROSS BOLT SPACER	NTS

A	06.01.04	NEW ISSUE



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
2) ALL DIMENSIONS ARE IN INCHES
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10 9933MCT 15-12-07

RELEASED 06-02-07

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